



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.1914

Job Sheet 171193



Part No: 647.1914

Job Qty: 5 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/28/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV n/c SHEETS 1,2,6 IPP REV:A RQ 13/11/01 new issue VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Machining-1		DAS
100	Bandsaw	5 pcs	2/27/18	2/27/18	0.00	0.05	Bandsaw1		54
110	CNC Vertical Machining	5 pcs	2/28/18	2/28/18	0.10	4.17	HAAS1-1		9-89
120	QC	5 pcs	2/28/18	2/28/18	0.00	0.00	QC2 Machining-1		
130	QC	5 pcs	2/28/18	2/28/18	0.00	0.00	QC8 Machining-1		
140	Outsource	5 pcs	2/28/18	2/28/18	0.00	0.00	Outsource4		
150	Packaging	5 pcs	2/28/18	2/28/18	0.00	0.00	Packaging2		
155	QC	5 pcs	2/28/18	2/28/18	0.00	0.00	QC5		
180	Packaging	5 pcs	2/28/18	2/28/18	0.00	0.00	Packaging3-1		
190	QC21-SA	5 Ea	2/28/18	2/28/18	0.00	0.00	QC21		DAS 9-89

Part Op 100 - Cut Blanks at 2.00"

Descriptions: 110 - 1-Machine per folio FB225 FOLIO REV: 2- deburr and break all sharp edges

140 - Issue P/O to ATG: 20029898 1- Black Anodize as per Dwg 647.1900

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B1.250X2.000	7075-T6 Bar 1.250" X 2.000"	.8300 ft (.166 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6B1.250X2.000	1	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	1.000Inches ± 0.010	1.010 0.990		
2	Bracket	1.660Inches ± 0.010	1.670 1.650		
3	Bracket	1.840Inches ± 0.010	1.850 1.830		
4	Bracket	0.380Inches ± 0.010	0.390 0.370		
5	Bracket	0.070Inches ± 0.010	0.080 0.060		

Plex 1/31/18 9:48 AM Dart.Gagnon.Michelle

DART
AEROSPACE

Container No: S070833



Part: 647.1914

Job No: 171193

Serial No/Batch: S070833

Revision:

Inspector:

1270 Apprahen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/12/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

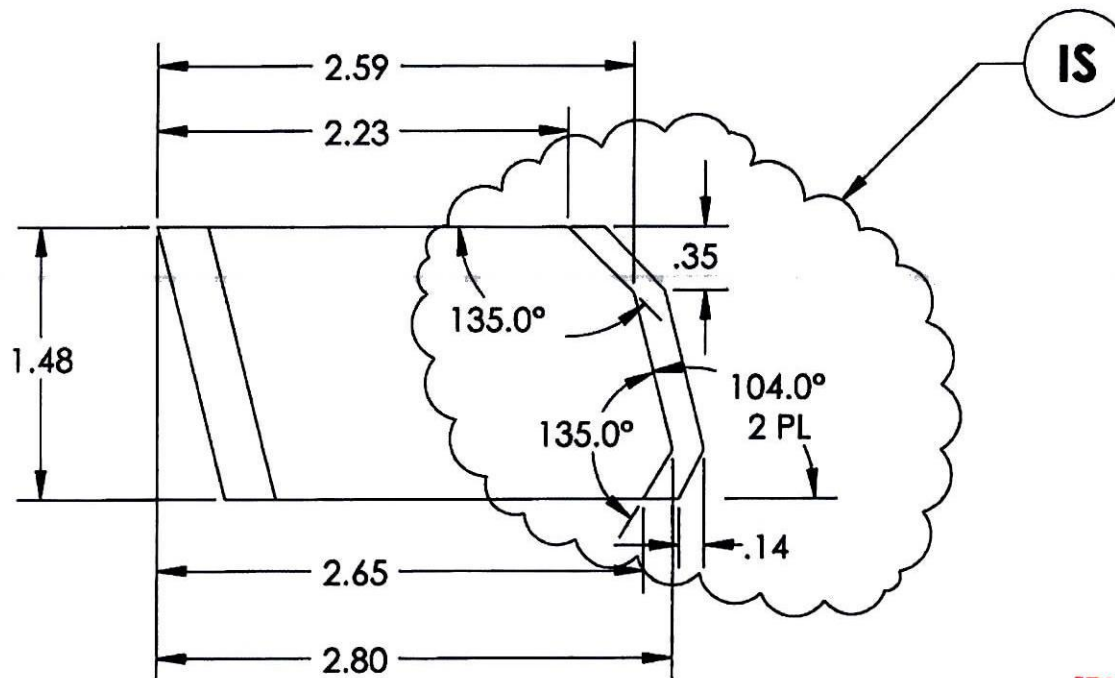
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03811				SHEET 1 OF 1	
	DWG NO. 647.1900	REV: N/C	PREPARED BY B. PETERS	DATE: 02/13/13	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKETS					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF. NEXT ORDER		
TRANSACTION CODES (TC): A-ADD R-REVISE C-CREATE D-DELETE	REASON: CORRECTED DIMENSION CONFLICT & INCORPORATED ECN 03699.					ECR: 13-06

SHEET 2, ZONE C3 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171193
JAN 31 2018

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03699				SHEET 1 OF 1	
	DWG NO. 647.1900	REV: N/C	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKETS					
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>David Barber</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE MATERIAL.			ECR: D-12-018	

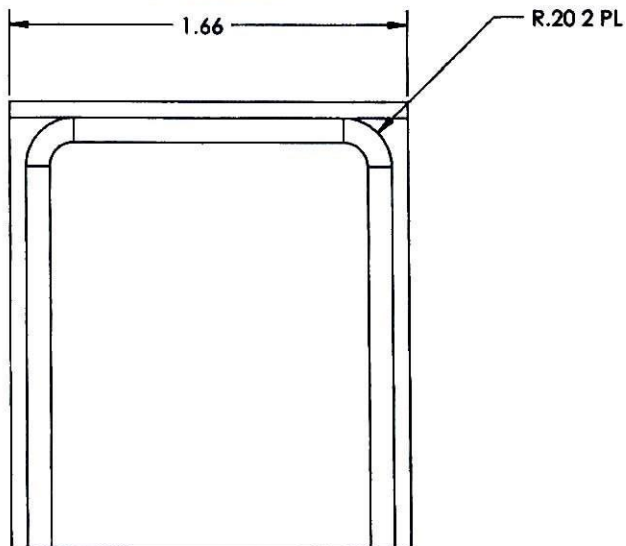
IS

⚠ PRIMARY MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

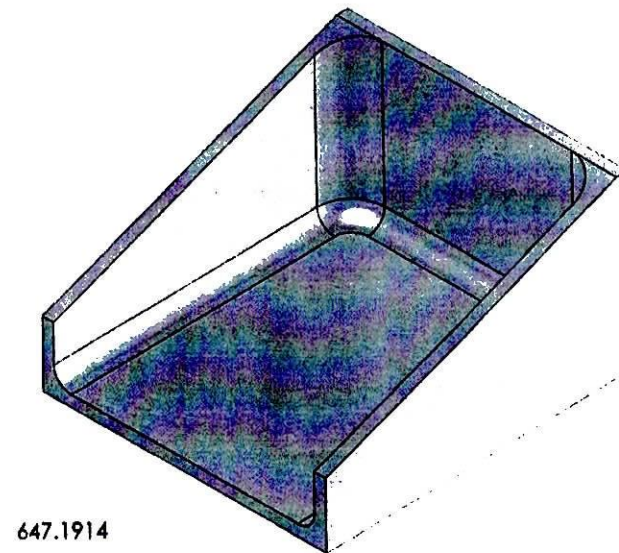
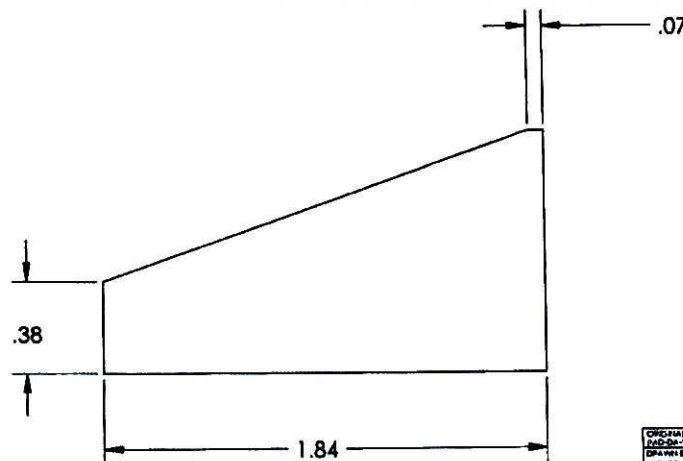
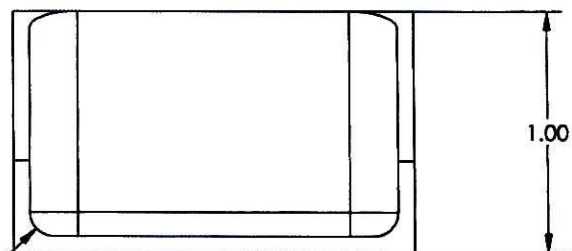
SHEET 1, ZONE A2 IS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY	DER REVIEW REQUIRED
☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM					☐ MAJOR ☒ MINOR	☐ YES ☒ NO

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2 PL



ORIGINAL DATE 01-01-98		APICAL INDUSTRIES	
DRAWN BY J. GARDNER	CHECKED P. BRAVO	2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO	CONTRACTING	BRACKETS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET B	REV NIC
CAGE CODE 07M26		DWG. NO. 647.1900	SCALE NONE
		SHEET 4 OF 5	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO039898

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No:	PO039898
PO Date:	5/14/18
Due Date:	5/25/18
Purchase Order	
Revision:	
Revision Date:	
Ship-To Contact:	Tsimiklis, ChrisoulaPhone:

Via:	Ground
Pymt Terms:	Net 30
Freight Terms:	
Special Comments:	

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177019	649.4818	Shim Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	5/18/18	12 pcs	0 pcs	12 pcs	\$7.85/pcs	\$94.20
2	175987	646.3810	Bracket Issue P/O to ATG : _____ 1- Hard Anodize Black and Prime as per Dwg 646.3800	Firmed	5/18/18	20 pcs	0 pcs	20 pcs	\$7.85/pcs	\$157.00
3	176311	646.3814	Wiper Bracket Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	5/18/18	20 pcs	0 pcs	20 pcs	\$7.40/pcs	\$148.00
4	175988	646.3812	Gusset Bracket Issue P/O to ATG : _____ Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	5/18/18	20 pcs	0 pcs	20 pcs	\$7.40/pcs	\$148.00
5	176232	646.3811	Radius Block Issue P/O _____ ATG, black anodize and prime as per dwg 646.3811 Rev. A	Firmed	5/18/18	24 pcs	0 pcs	24 pcs	\$7.85/pcs	\$188.40

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	177018	649.4815	Shim ISSUE P/O: _____ HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) C OF C IS REQUIRED	Firmed	5/18/18	24 pcs	0 pcs	24 pcs	\$13.45/pcs	\$322.80
7	171193	647.1914	Bracket Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 647.1900	Firmed	5/18/18	5 pcs	0 pcs 5x	5 pcs	\$9.80/pcs A119/05/12	\$49.00
8	173515	RBT400229-01	Left Side -Issue P/O to ATG: _____ - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	5/18/18	10 pcs	0 pcs	10 pcs	\$13.80/pcs	\$138.00
Grand Total:										\$1,245.40
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 5/23/18 4:02 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915238

Date: 25-May-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4 mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23090	Rev: NC	PO: PO039898 Line: 2
20 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23092	Rev: N/C	PO: PO039898 Line: 4
5 ea	Part: 647.1914 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Job: 23095	Rev: N/C	PO: PO039898 Line: 7
10 ea	Part: RBT400229-01 Left Side Anodize per MIL-A-8625F, Type II, Class 1, Clear, Water Seal .0004-.0010" (.4 - 1 mils) Job: 23096	Rev: 2	PO: PO039898 Line: 8
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>25/5/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ Made in Canada.			